

Work Order ID 98154

98154

Page 1

Friday, March 08, 2013 8:51:29 AM

Item ID: D4484-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Nutplate Retainer

Stop ***NS2***

Start Date: 3/8/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/14/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MUC*

Date: *13-3-08* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4484	C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

10

DAS
05
9-89

13-03-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

DAS
05
9-89

13-03-10

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10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

C'SINK HOLES AS PER DWG

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

SMP
13 312

10X

13/03/13

DAS
27
15 3 13

10

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Cust Item ID:

Required Date: 3/14/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

10 16133-13

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

10

DAS
05
9-8 13-03-14

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

Prime tempo grey as per dwg (note 2)
Batch: 117319

10

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H

13-3-14

Work Order ID 98154

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N900040100

Setup Start

NS1

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Item Name: Nutplate Retainer

Stop

NS2

Start Date: 3/8/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/14/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours **DAS**

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: **CA.**

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

27
9-89
14/3/7

10

MF 14-3-7

14-03-7

MF

14-3-07

Picklist Print

Friday, March 08, 2013 8:51:29 AM

Page 1

Work Order ID: 98154
 Parent Item: D4484-5
 Parent Item Name: Nutplate Retainer

Start Date: 3/8/2013 Required Date: 3/14/2013
 Start Qty: 10.00 Required Qty: 10.00

Comments: IPP REV:A 12.05.14 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	292.0625		0.1684211		13-03-10	

Location

MAT021

123135

124003

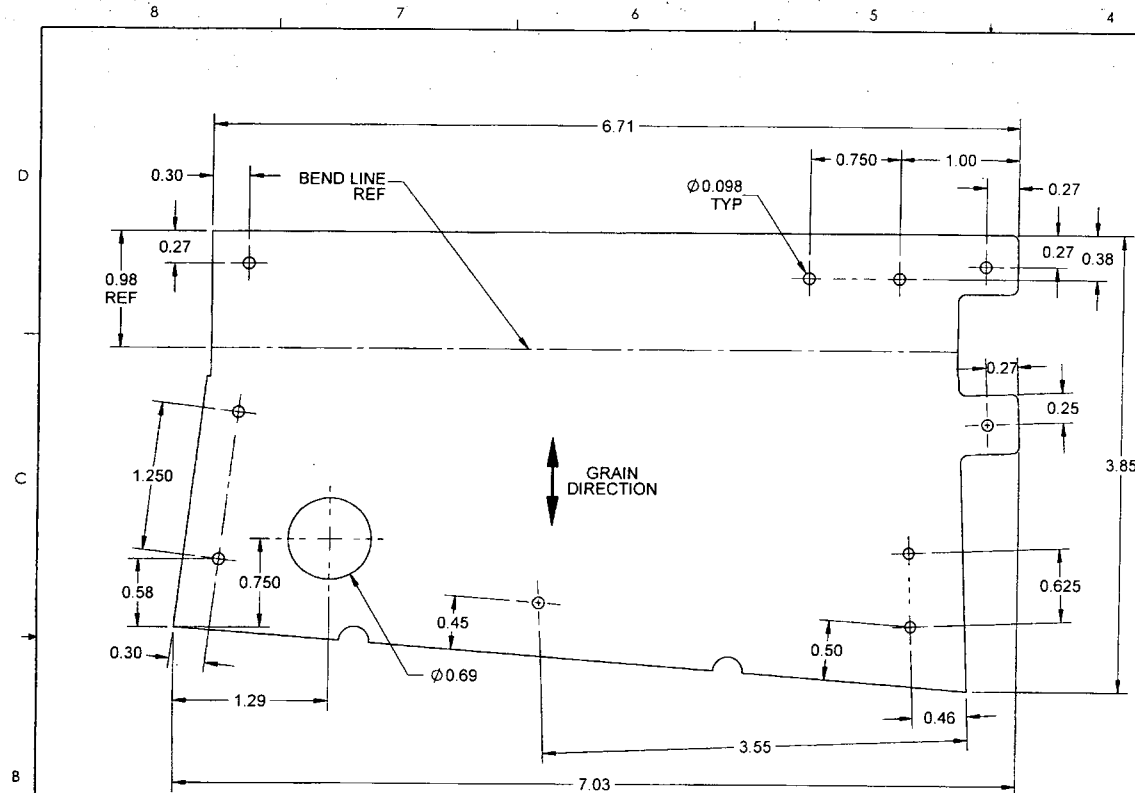
Loc Qty

292.0625

120.5625

171.5

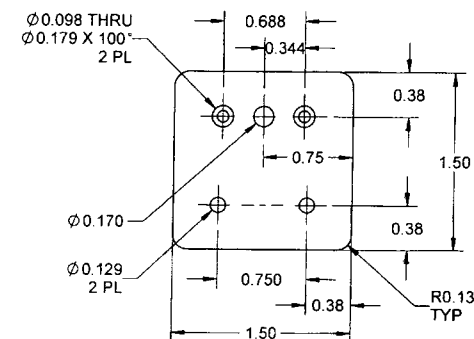
Loc Code



8 D4484-3F AFT BOTTOM PANEL (LH)
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4484-3F-REVC.DXF"



D4484-5 NUTPLATE RETAINER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2012-11-29
M

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4484	SHEET 8 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BOTTOM PANEL ASSY	NTS
DATE	12.10.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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